



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2891-1
Job Sheet 192368



Part No: D2891-1

Job Qty: 10 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	4/12/19		0.00	8.20	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	10 pcs	4/12/19		0.00	0.00	QC 2 - 1		M.M. 2019/01/29
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		

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Container No: S176294



Part: D2891-1

Job No: 192368

Serial No/Batch: S176294

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/29/19

DAS
40
9-89

120 QC 8	10 pcs	4/12/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mm. 2019/04/26
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130 Crosstubes - 2 - B4B	10 pcs	4/12/19	0.00 0.47	QC 8 - 1 (A)	Kt 19-05-01
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 QC 3	10 pcs	4/12/19	0.00 0.00	Crosstubes - 1 - B4B	RD 19-5-2
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
170 Packaging 3-1 - Stock - B4B	10 pcs	4/12/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

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9-89
MAY 03 2019

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC LG050
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAS MAY 03 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. *5132100 ex 20/11*

140 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____ LOCATION : LG052

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	5 pcs (.5 ea)	100-HAAS 4 Axis	<i>5167691</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK076	5	5	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.188	.188	.188	.188	.188
AB	0.240	0.260		.248	.249	.249	.250	.248
AC	0.115	0.150		.124	.123	.125	.125	.123
AD	0.040	0.060		.053	.054	.055	.056	.058
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.137	.136	.135	.136	.135
AI	0.454	0.474		.459	.460	.456	.456	.456
AJ	2.779	2.789		2.781	2.781	2.780	2.740	2.781
AK	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AL	1.002	1.042		1.038	1.037	1.037	1.036	1.035
AM	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.674	1.674	1.673	1.673	1.673
AP	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AQ	0.022	0.042		R.032 OK	R.032 OK	R.032 OK	R.032 OK	R.032 OK
AR								
AS								
AT								
Accept/Reject								

Measured by: LM **Date:** 2019/04/28

Audited by: KA **Date:** 2019/05/01

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number: D2891-1	
Inspection Dwg: D2891		Rev: B	
		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.188	0.193		.1880	.1880	.1880	.1880	.1880
AB	0.240	0.260		.247	.248	.248	.246	.246
AC	0.115	0.150		.124	.123	.124	.124	.124
AD	0.040	0.060		.059	.058	.058	.057	.058
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.135	.136	.136	.136	.136
AI	0.454	0.474		.457	.458	.456	.454	.454
AJ	2.779	2.789		2.781	2.781	2.781	2.781	2.781
AK	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AL	1.002	1.042		1.035	1.034	1.035	1.038	1.039
AM	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AN	0.257	0.262		.2570	.2570	.2570	.2570	.2570
AO	1.663	1.683		1.672	1.677	1.673	1.672	1.671
AP	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AQ	0.022	0.042		R.032 ok	R.032 ok	R.032 ok	R.032 ok	R.032 ok
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>MM</u>	Date: <u>2019/04/29</u>
Audited by: <u>KA</u>	Date: <u>2019/05/01</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	